

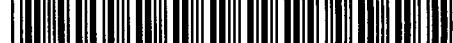
**Work Order ID** 56580

Page 1

March 1, 2010 2:47:34 PM

**Item ID:** DSK078

Accept



Setup Start

**Revision ID:**

Stop

**Item Name:** D2893-1 TURNING DETAIL

Stop

**Start Date:** 3/01/10 **Start Qty:** 10.00**Cust Item ID:****Required Date:** 3/08/10 **Req'd Qty:** 10.00**Customer:****Reference:****Approvals:** Process Plan: *CL*

Date: 03/01/10 Tooling:

Date:

Run Start



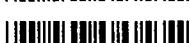
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A	0.00							
100	MORI SEIKI CNC LATHE LARGE	0.00							
	Doosan	0.00							
Doosan Lathe	<b>Memo</b>								
	Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	<b>Memo</b>								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	<b>Memo</b>								

*SL*  
SA 10/03/28

*SL*  
SA 10/03/28

*MK*  
10/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56580**

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March 1, 2010 2:47:34 PM

Item ID: DSK078

Accept



Setup Start



Revision ID:

Item Name: D2893-1 TURNING DETAIL

Stop



Start Date: 3/01/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

0.00

MMJ  
10/03/29

10

X

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: DSK078

140



QC21- Final Inspection - Work Order Release

0.00

10/03/30 HJ

QC

Memo

0.00

Quality Control

B/10-3-29  
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 1, 2010 2:47:33 PM

Page 1

Work Order ID: 56580



Parent Item: DSK078



Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP rev A. 08.03.13 new issue EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	0.0000	10.0000			

Round Billet, 17-4



BS6585 x 10 31/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56580
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A			Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.074	3.074	3.074	3.074
D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.944	2.944	2.944	2.944
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.119	.119	.118	.119
L								
M								
N								
O								
P								

Measured by: MM Date: 10/01/20 / 10/01/20

Audited by: Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	MM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

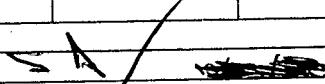
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56580
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	110
Lathe Section								
A	2.707	2.712		2.710	2.710	2.709	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.075	3.075	3.073	
D	0.718	0.738		.725	.725	.725	.725	
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: 

Date: 10/03/28

Audited by: MNZ/10/03/28

Date:

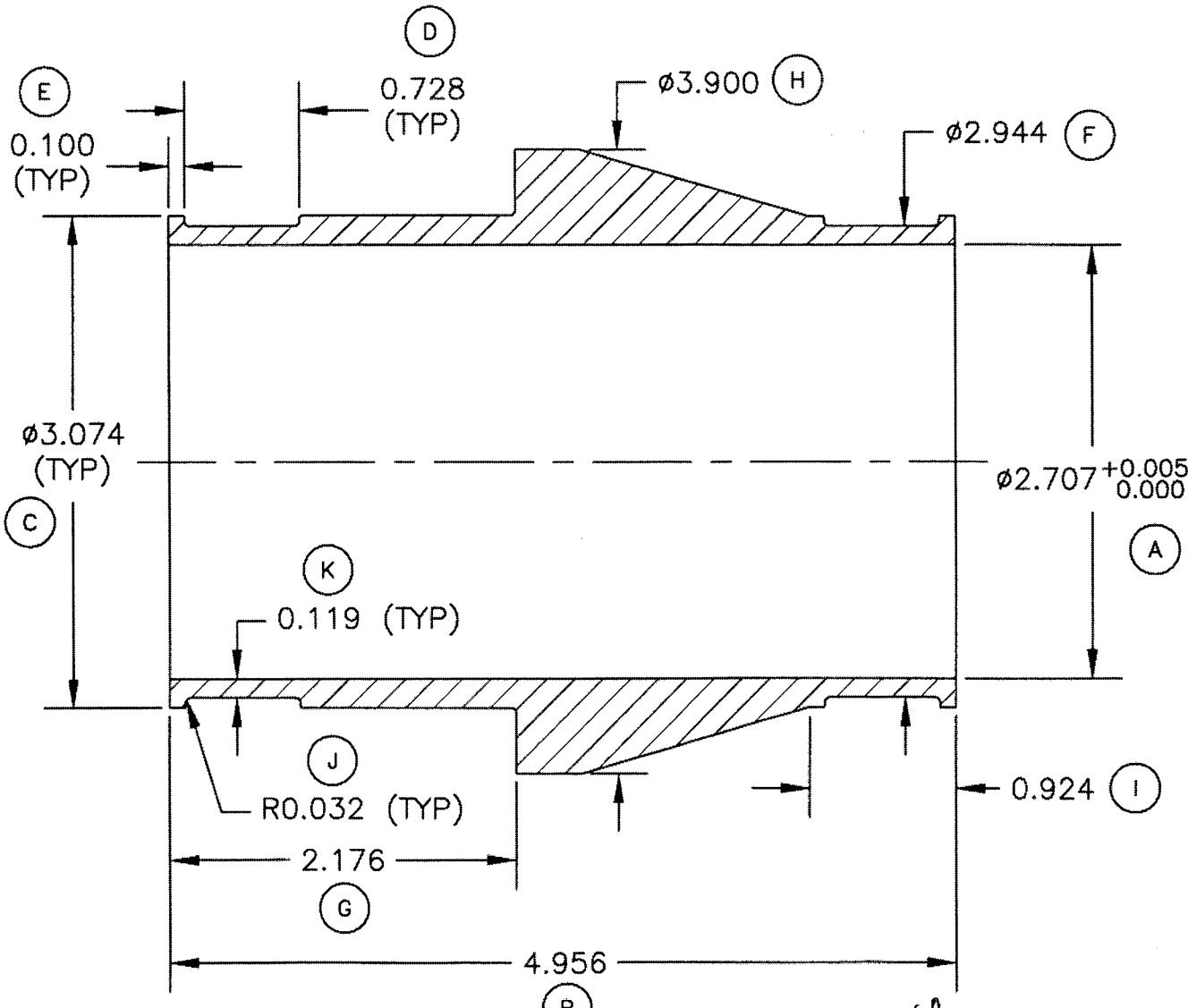
Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

**DART**

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>df</i>	APPROVED <i>ff</i>	DRAWING NO. DSK 078 REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1 SCALE 1:1
A	03.05.20	NEW ISSUE

RELEASED  
*03.07.01**2.946*D2893-1 TURNING DETAIL

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries